



Owner's Manual XACTA[®]Fence II Commercial 30/50



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Part No. M-708950Z
Revision L2 07/2019
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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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The specifications in this manual are given as general information and are not binding. JET reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. The Table Saw on which the XACTA Fence II is used is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a Table Saw, do not use until proper training and knowledge have been obtained.
5. Do not use this Table Saw on which the XACTA Fence II is used for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this Table Saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating the Table Saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
10. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
11. Make certain the machine is properly grounded.
12. Make all machine adjustments or maintenance with the machine unplugged from the power source.
13. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
14. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
15. Make sure the Table Saw is firmly secured to the floor or bench before use.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**
20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall into the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep saw blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.

26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

⚠ WARNING: This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

⚠ WARNING: Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection.

Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠ WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

Ordering Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Unpacking

Open shipping cartons and check that all parts are intact. Report any damage immediately to your distributor. Read the instruction manual thoroughly for assembly, alignment, and maintenance instructions.

Contents of the Shipping Containers

- 1 XACTA Fence II
- 1 Front Rail
- 1 Rear Rail
- 1 Guide Rail
- 3 Black Plastic End Caps
- 1 Hardware Package
- 1 Owner's Manual
- 1 Warranty Registration Card

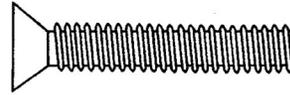
The contents of the hardware bag are drawn full scale in Figure 1.

Note 1: Quantities may vary depending upon whether you purchased the short rail or long rail.

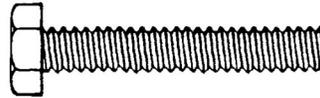
Note 2: If the optional wooden extension table is not used, there will be extra hardware.

Tools Required for Assembly & Adjustment

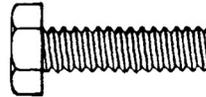
- 1 #3 Cross Point Screwdriver
- 1 7/16" Wrench
- 1 1/2" Wrench
- 1 Combination Square & Straight Edge
- 1 Electric Drill
- 1 1/4", 3/16" Drill Bits
- 2 4"-6" C-Clamps
- 1 1/4", 3/16" Allen Wrenches



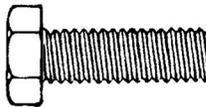
Flat Head Screw
1/4-20 x 1-1/2



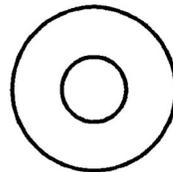
Hex Cap Screw
1/4-20 x 1-1/2



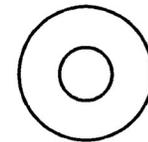
Hex Cap Screw
1/4-20 x 3/4



Hex Cap Screw
5/16-18 x 3/4



5/16 Flat Washer



1/4 Flat Washer



1/4 Lock Washer



1/4 Hex Nut

Installation

Tools required

- 7/16" and 1/2" wrenches
- Cross point screwdriver
- 3/16" hex wrench
- Adjustable square
- Hammer (or rubber mallet)
- Straight edge

The following instructions are for installing the XACTA Fence II and Rail System on JET Models JTAS-10, JTAS-12 and XACTA® Saw Deluxe series table saws. The rails should bolt up to the JET saw without any drilling.

Front Rail Installation

Referring to Figures 1 and 2:

1. Identify the *front rail* (E), which is 2-1/2" x 2-1/2" with notches on one side and countersunk mounting holes on the other side.
2. Lightly secure the *front rail* (E) to the table (G) and *extension wings* (F) with four each 1/4 x 1-1/2" *flat head screws* (A), 1/4" *flat washers* (B), 1/4" *lock washers* (C) and 1/4" *hex nuts* (D). Tighten just enough to hold the rail next to the table but keep loose enough to allow height adjustment.

The *front rail* must be 9/16" down from the table top in order to clear the miter gauge slot. This measurement is critical.

3. Place an adjustable square on the table as shown in Figure 3.
4. Check the height of the front rail at several locations along the surface of the saw table. The front rail **must** be parallel with the table top.

When the front rail has been correctly positioned:

5. Use a #3 cross point screwdriver and 7/16" wrench to tighten all mounting screws securely. However, do not tighten hardware for the *left extension table* (shown in F, Fig. 1).

The hardware that secures the left extension table should be left loose to accommodate the switch installation (below).

Switch Installation

At this time refer to your JTAS-10, JTAS-12 or XACTA® Saw manual and attach the switch as described in the *Switch Installation* section. The switch *should* be attached before the guide tube installation covered later in this manual.

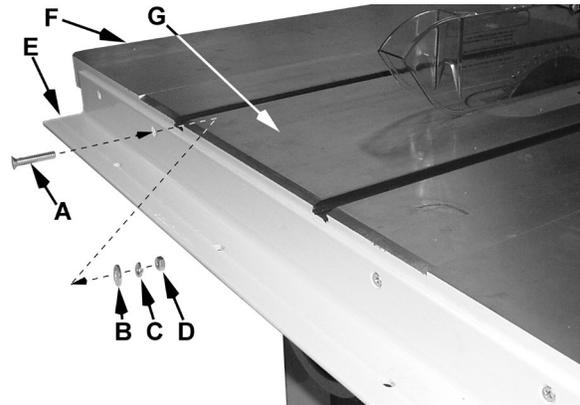
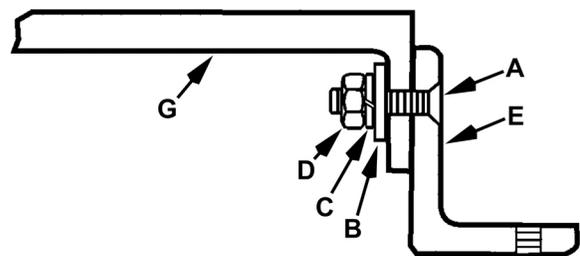


Figure 1



- A - 1/4'-20 x 1-1/2" Flat Head Screw
- B - 1/4" Flat Washer
- C - 1/4" Lock Washer
- D - 1/4" Hex Nut

Figure 2

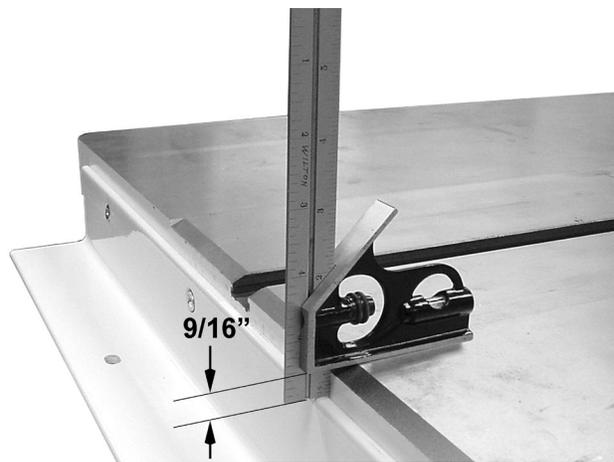


Figure 3

Back Rail Installation

1. Locate the *back rail* which is 2" x 2" with holes running along one side only. The height of the *back rail* when attached to the saw is not critical.
2. Align the holes in the *back rail* to the holes in the table top, as shown in Figure 4.



Figure 4

3. Secure the back rail to the pre-tapped holes in the saw table (B, C, Fig. 4) with two 5/16 x 3/4 hex cap screws and two 5/16 flat washers, as shown in Figure 5. Tighten screws securely with a 1/2" wrench.



Figure 5

4. Secure the back rail at A and D (in Figure 4) to each *extension wing* with a 1/4 x 1-1/2 hex cap screw, two 1/4" flat washers, a 1/4" lock washer, and a 1/4" hex nut as shown in Figure 6.
5. Tighten nuts.

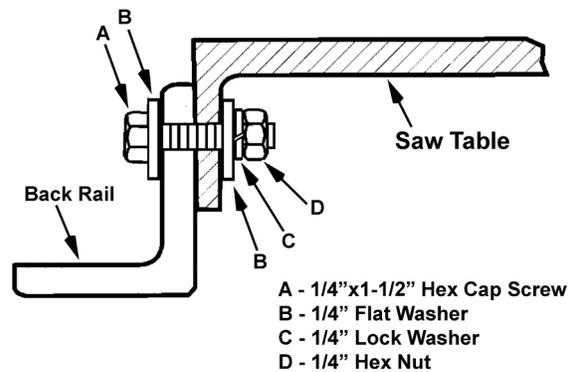


Figure 6

Important: If you are installing an optional wood extension table on your saw, it should be installed first **before** mounting the guide tube. This will prevent having to mount and align the guide tube twice.

If you are not mounting an optional wood table, proceed to *Guide Tube* section.

Wooden Extension Table

The *wooden extension table* is an optional accessory.

Tools required

Electric drill
Cross point screwdriver
7/16" and 1/2" wrenches
Four clamps
Straight edge
Hammer (or rubber mallet)

Installation

The optional wood extension table (including the optional router table) sits flush against the saw table and along the inside of the rails. The JET logo (or warning label on the router table) should face outward. The extension table is not bolted to the saw table, it is bolted only to the rails.

The extension table and saw table must be aligned properly so the XACTA Fence II will slide smoothly from one to the other.

1. Place the extension table between the rails and up against the saw table, leaving the extension table raised just slightly above the saw table. Clamp the extension table to the front and back rails as shown in Figure 7. Clamping pressure should be enough to secure the table yet allow minor adjustments.
2. Use a hammer and block of wood (or a rubber mallet) to tap the extension table up flush against the cast iron saw table (Figure 7). Then tap down the extension table at various points along its edge where it meets the saw table, until it is level with the saw table (Figure 8). As one part of the edge becomes level with the table, tighten the clamp on that side. Then move to the other side and repeat, until the full length of the edge is level with the saw table. Lay a straight edge across both extension table and saw table to ensure proper leveling.

When extension table is properly aligned, holes need to be drilled into the wood table using the holes in the rails as your guide (Figure 9). *You may wish to drill 3/32" pilot holes first.*

3. Drill 1/4" holes into the front edge of the table using the holes in the front rail as a guide. Drill 1/4" holes into the back edge of the table using the holes in the back rail as a guide.
4. Install three 1/4 x 1-1/2 flat head screws, three 1/4 flat washers, and three 1/4 hex nuts into the holes in the front edge of extension table as shown in Figure 10. Finger tighten only.

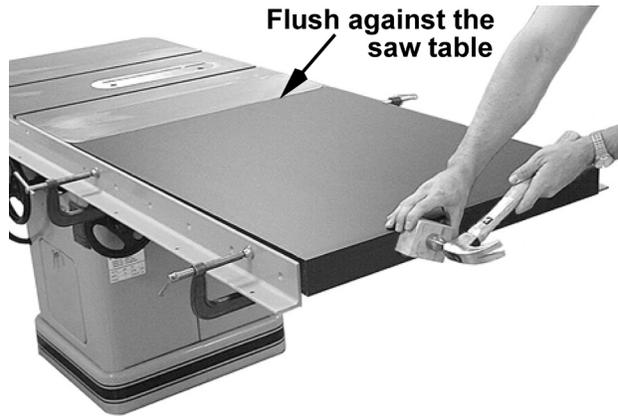


Figure 7

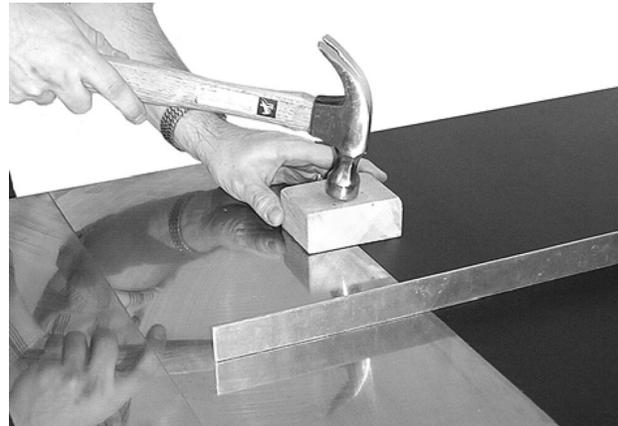


Figure 8

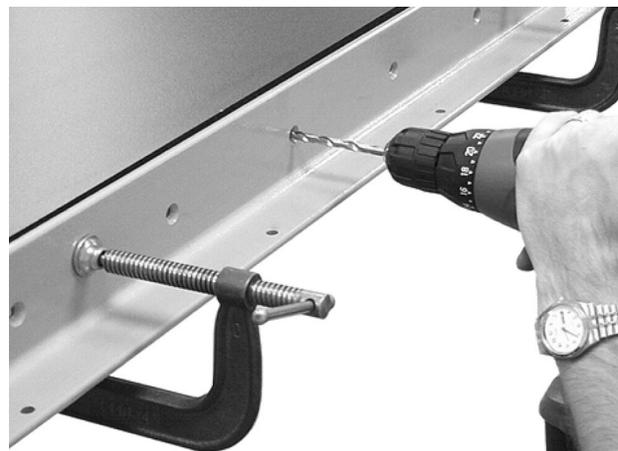


Figure 9

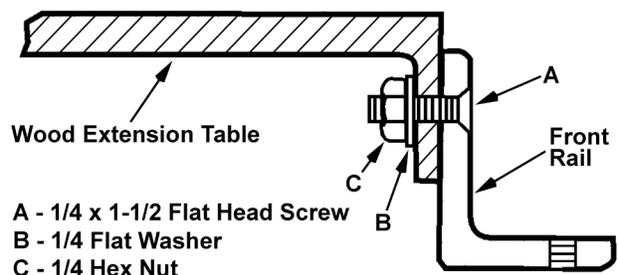


Figure 10

5. Install three 1/4-20 x 1-1/2 hex cap screws, three 1/4 flat washers, and three 1/4 nuts into the holes in the rear edge of extension table as shown in Figure 11. Finger-tighten only.
6. Re-check the table for alignment, make further adjustments if necessary, then tighten all screws and nuts.
7. Mount the two legs to the inside corners of the extension table as shown in Figure 12. Secure with the eight screws provided.

Note: If you are using a mobile base under your saw, you may need to shift the placement of the legs so they rest properly upon the shelves of the base.

8. Adjust the footpads on the legs counterclockwise until they reach the floor, then tighten the nut.

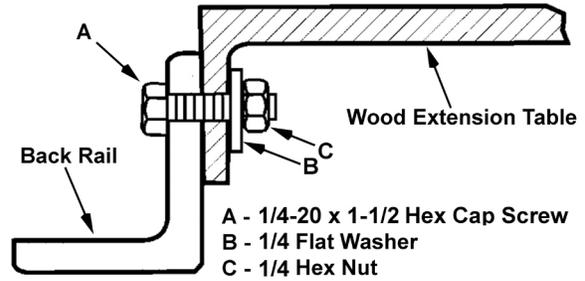


Figure 11



Figure 12

Guide Tube

Important: Before proceeding with the *guide tube* installation, the *table saw switch* should already be installed. If not, refer to the *Switch Installation* section in your JTAS-10, JTAS-12 or XACTA® Saw manual.

Referring to Figure 13:

The *guide tube* (A) is placed on top of the *front rail* (B) and is mounted with the scale facing toward the operator.

1. Align the holes in the bottom of the *guide tube* with the holes in the *front rail*. When properly positioned the *guide tube* should extend beyond the *front rail* about 6" in both directions.
2. Fasten the *guide tube* (A) to the rail (B) from beneath, with seven 1/4-20 x 3/4 hex head screws (B), seven 1/4" lock washers (F) and seven 1/4" flat washers (G). Finger tighten only.
3. Tighten all screws with a 7/16" wrench.

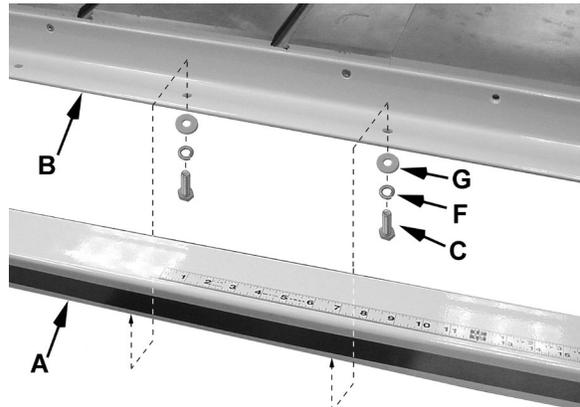


Figure 13

XACTA Fence

Screw the lock lever knob into the threaded handle on the XACTA Fence II as shown in Figure 14.

The lock lever has three functional positions as shown in Figure 15:

- The upright position permits mounting and removal of fence from the saw.
- The unlock position permits easy fence positioning.
- The lower position locks the fence to the front rail. The cam handle should be pushed down firmly against the pin.

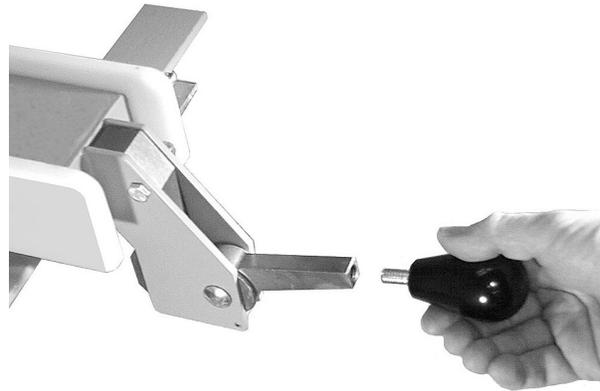


Figure 14

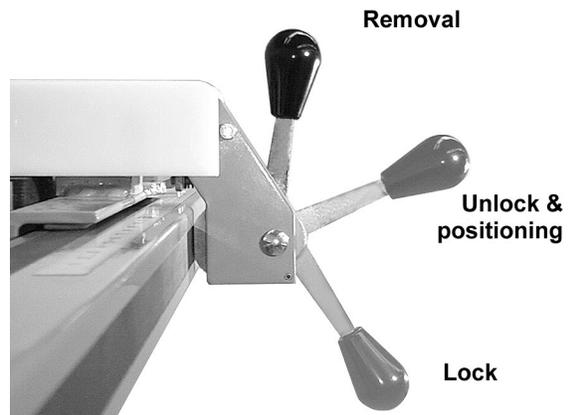


Figure 15

Leveling Fence to the Saw Table

1. Place the fence on the table and lock it.
2. View the fence from the left side of the saw (Figure 16). Look for the space *between the table and the fence bottom* to be equal along the entire length of the fence (A, B, Fig. 16).

If adjustment is necessary:

3. Unlock the fence.
4. Raise or lower two nylon adjustment screws (D, Fig. 17) *the same number of turns* until the space between the bottom of the fence and the table is the same. Care must be taken to raise or lower the fence on each side equally or the fence may not be 90° to the table after the height adjustment is performed.

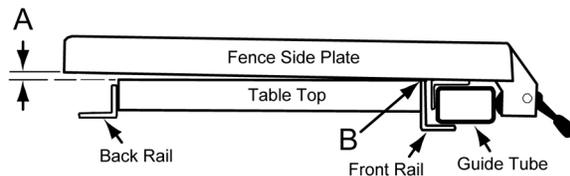


Figure 16

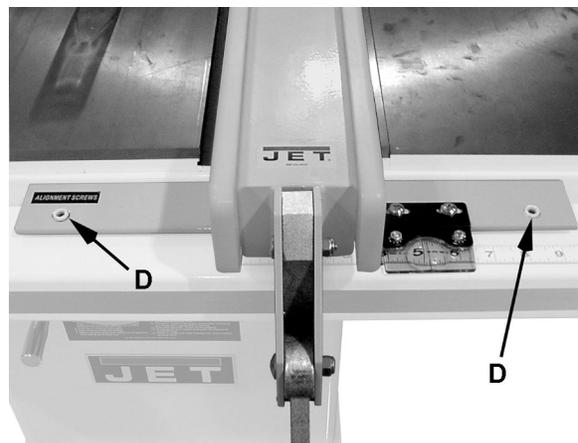


Figure 17

Adjusting Fence Parallel to the Miter Slot

1. Place the fence next to the outside edge of the right miter slot and lock it.
2. The fence should be even with the miter slot from front to back.
3. If the fence is not even along the length of the miter slot, unlock the fence, remove it and turn upside down.
4. Adjust one of the two setscrews (A, Fig. 18) until the fence is even with the miter slot edge along its entire length when locked.

Note: You may need to re-adjust the clamping pressure after aligning the fence.

Clamping Pressure

The XACTA Fence II has been adjusted at the factory to lock securely when the lock handle is pushed down. If adjustment is needed:

1. Unlock the fence.
2. Remove the fence from the guide rail.
3. Turn the fence over.
4. Adjust each of the two setscrews (A, Fig. 18) exactly the same number of rotations until the fence is held securely when the lock handle is pushed down.

90° to the Table

1. Place the fence on the saw table and lock it.
2. Place a square (A, Fig. 19) on the table next to the fence. The fence should be 90° to the table.
3. If adjustment is necessary, unlock the fence, and turn one of the two nylon adjustment screws (B, Fig. 19) until the fence is 90° to the table.
4. Lock the fence and check the adjustment again.

Cursor Adjustment

1. Disconnect the table saw from the power source.
2. Raise the saw blade above the tabletop.
3. Unlock the fence and slide it to approximately four inches from the saw blade.
4. Lock the fence.
5. Measure the distance between the saw blade and the inside of the fence.
6. Adjust the cursor (C, Fig. 19) to read the distance just measured and tighten the cursor assembly to the fence.
7. Take a test cut and confirm the adjustment is correct.



Figure 18

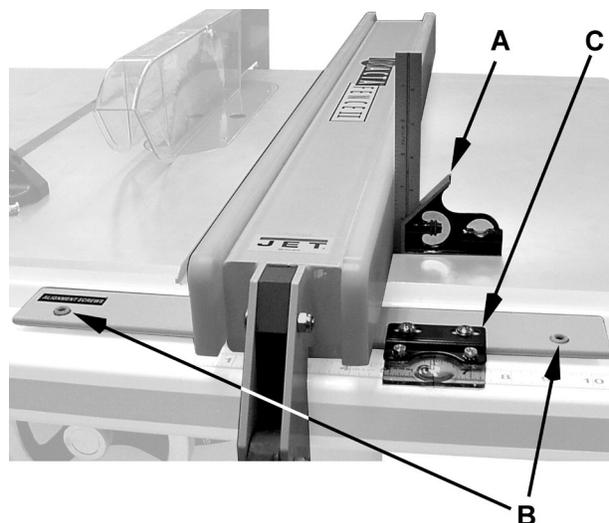


Figure 19

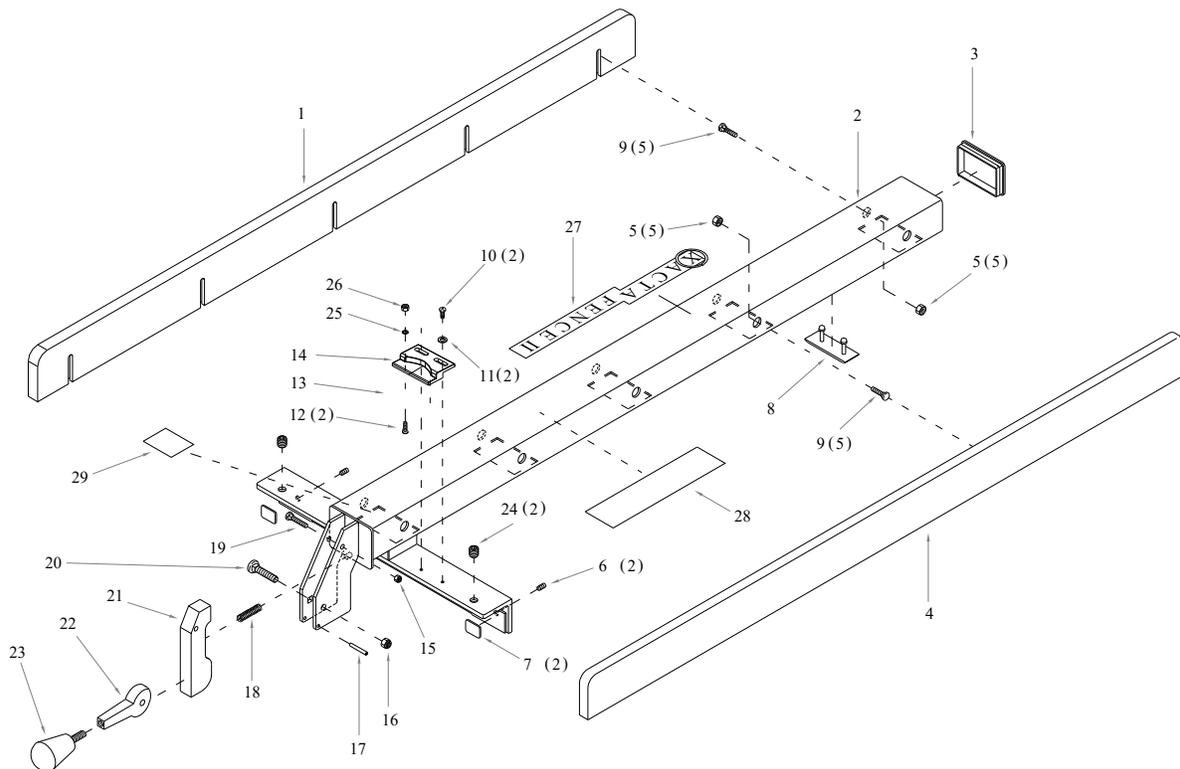
Note: If the cursor does not have enough travel to give the correct measurement loosen the guide rail and adjust as needed. If you still do not get the correct measurement loosen the front rail and adjust as needed. If you have to adjust the front rail you will need to go through the front rail assembly instructions again.

This adjustment must be checked whenever a different blade is installed.

After installing the XACTA Fence II press the black plastic end caps into the openings of the guide rail. There is also an end cap for the fence, but this should already be installed.

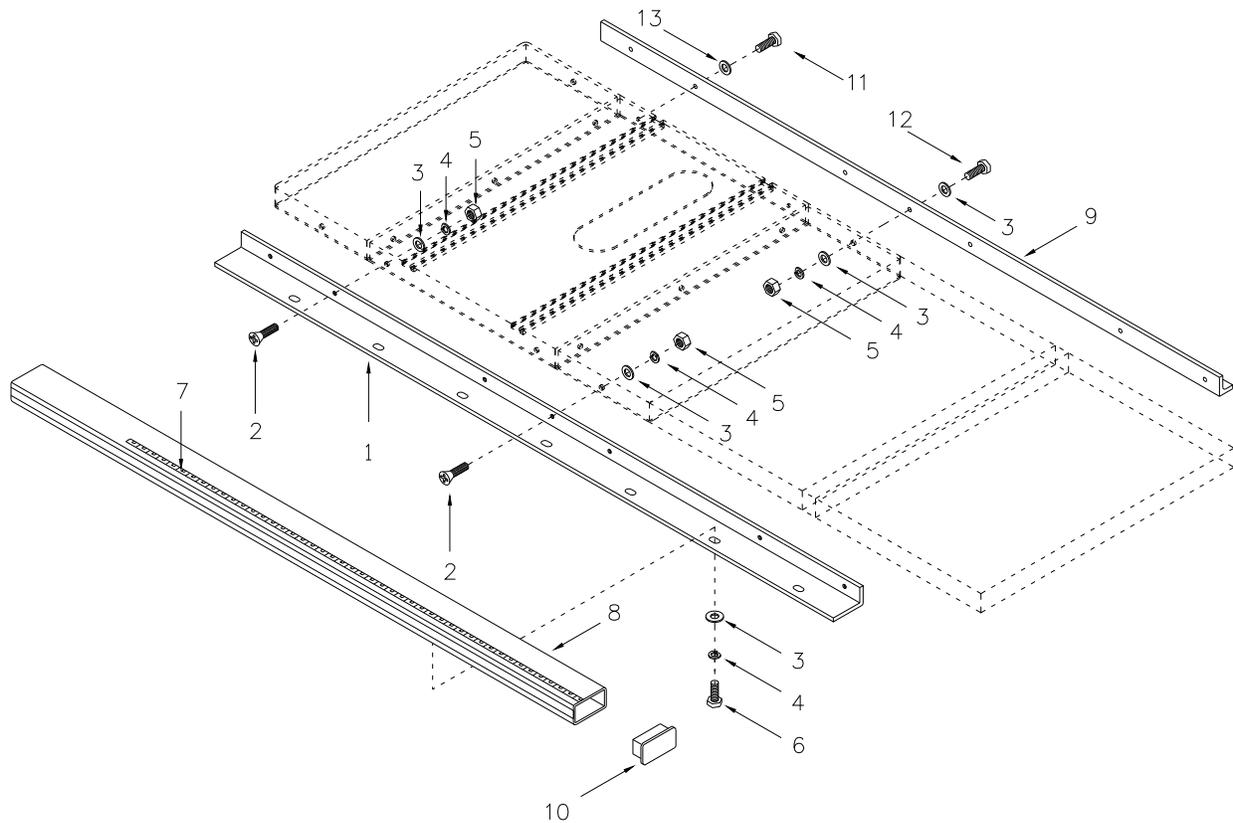
Parts for the XACTA Fence II Commercial 30/50

Index No.	Part No.	Description	Size	Qty
	708950Z	XACTA Fence II Commercial (includes #1-29)		1
1	XF2-101N	Left Side Plate		1
2	XF2-102	Fence Body Assembly		1
3	XF2-103	Tube Cover		1
4	XF2-104N	Right Side Plate		1
5	TS-0640071	Lock Nut	1/4"-20	10
6	TS-0271031	Set Screw	3/8"-16 x 3/8"	2
7	3575081	Fluoroway Pad		2
8	XF2-108	Pad		1
9	XF2-9	T-Square Bolt	1/4"-20 x 3/4"	10
10	TS-081D022	Pan Head Machine Screw	10-32 x 3/8"	2
11	TS-0680021	Flat Washer	1/4"	2
12	TS-081D021	Flat Head Machine Screw	10-32 x 3/8"	2
13	800708950 D	Cursor		1
14	800708950 C	Cursor Bracket		1
15	TS-0640071	Lock Nut	1/4"-20	1
16	TS-0640091	Lock Nut	3/8"-16	1
17	XF2-117	Spring Pin	4mm x 28	1
18	6813042	Compression Spring		1
19	TS-0151041	Carriage Bolt	1/4"-20 x 1-1/2"	1
20	TS-0160021	Carriage Bolt	3/8"-16 x 1-1/2"	1
21	3215301	Foot Cam		1
22	3076232	Lock Cam		1
23	6430055	Knob w/stud		1
24	XF-5	Nylon Adjustment Screw		2
25	TS-0680021	Flat Washer	1/4"	2
26	TS-0560081	Hex Nut	10-32	2
27	XF2-127	XACTA Fence Label		1
29	XF2-129	JET Label		1



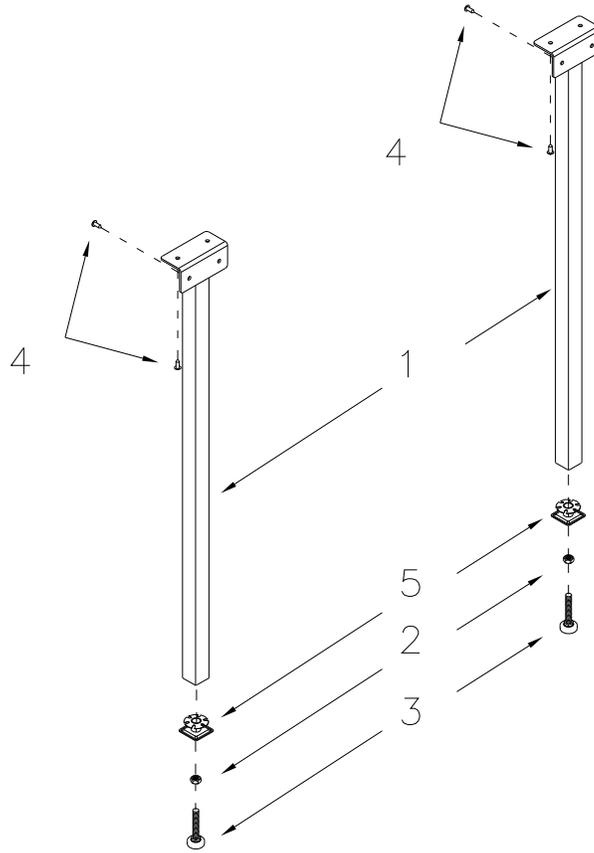
Parts for the XACTA Fence II Rail Assembly

Index No.	Part No.	Description	Size	Qty
	708930Z	XACTA II 30" Rail Set (includes #1-13)		
	708951Z	XACTA II 50" Rail Set (includes #1-13)		
1	XF2-201	Front Rail (50")		1
	XF2-201A	Front Rail (30")		1
2	TS-081F081	Flat Head Screw	1/4"-20 x 1-1/2"	7
3	TS-0680021	Flat Washer	1/4"	24
4	TS-0720071	Lock Washer	1/4"	19
5	TS-0561011	Hex Nut	1/4"-20	12
6	TS-0050031	Hex Cap Screw	1/4"-20 x 3/4"	7
7	XF2-207	Scale (50")		1
	XF2-207A	Scale (30")		1
8	XF2-208	Guide Rail (50")		1
	XF2-208A	Guide Rail (30")		1
9	XF2-209	Rear Rail (50")		1
	XF2-209A	Rear Rail (30")		1
10	XF2-210	Guide cover		2
11	TS-0081031	Hex Cap Screw	5/16"-18 x 3/4"	2
12	TS-0050071	Hex Cap Screw	1/4"-20 x 1-1/2"	5
13	TS-0680031	Flat Washer	5/16"	2



Parts for the XACTA Fence II Leg Assembly

Index No.	Part No.	Description	Size	Qty
1	XF2-301	Leg		2
2	TS-0561031	Hex Nut	3/8"-16	2
3	XF2-303	Adjusting foot		2
4	TS-1533052	Machine Screw	M5×16	8
5	XF2-305	Metal Insert	30 x 30 x 3/8"	2





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